

Date: Monday, 07/07/2008 4:23:02 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	MOUNTING LUG
<b>Job Number</b> :	40341		
<b>Estimate Number</b> :	10256		
<b>P.O. Number</b> :		<b>Part Number</b> :	D22303
<b>This Issue</b> :	07/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2230 REV F
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39404	<b>Drawing Revision</b> :	F
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	30/07/2008
<b>Written By</b> :		<b>Qty:</b>	200
<b>Checked &amp; Approved By</b> :	JUD 08 1.07	<b>Um:</b>	Each
<b>Comment</b> :	Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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**Comment:** Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion

D2423

Batch: B33310 CL

2.0	BAND SAW	BAND SAW
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cut at Metec

**Comment:** Band Saw

Cut D2423 extrusion to 0.82"

Batch: \_\_\_\_\_

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Issue P.O. 6711

C208/07/08

(200)

**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

Machine per drawing D2230 Rev F

4.0	QC8	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Receive + inspect for turnst. damage

C208/08/06

(200)

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Ensure C/C attached

5.0	QC5	SECOND CHECK
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counters

**Comment:** SECOND CHECK inspect level 5

C208/08/11

(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:23:02 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40341

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*Handwritten:* N/A 8/8/14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*Handwritten:* R/A 08/08/12 (200X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 8 08/08/12 (200)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*Handwritten:* 9:00  
320  
9:30

*Handwritten:* M-L 08/08/13

*Handwritten:* (200X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

*Handwritten:* 08-08-13 (200)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*Handwritten:* ST 476

*Handwritten:* AS 08/08/13 (200)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 08/08/13

Job Completion



*Handwritten:* MF 08-08-14

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

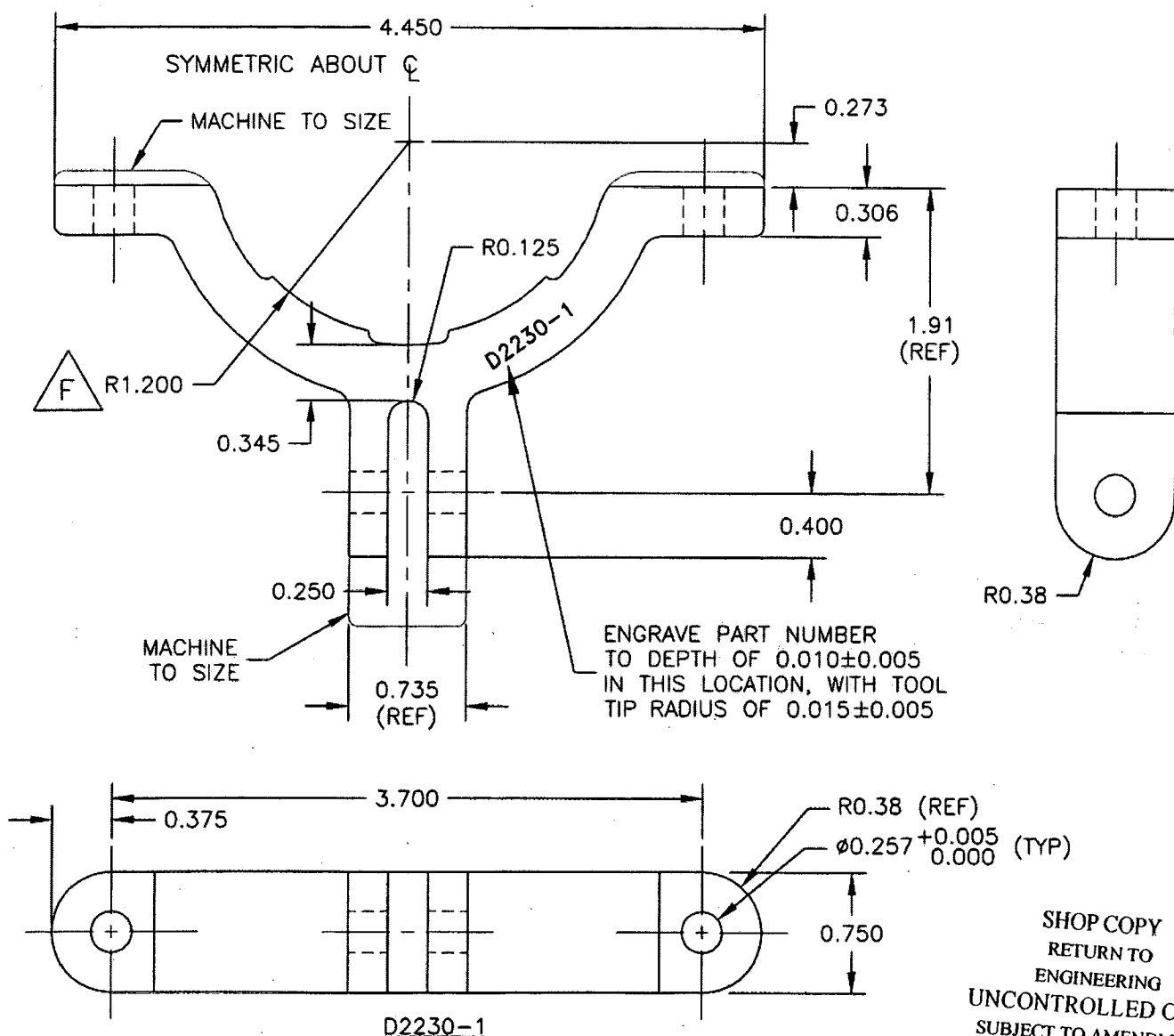
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		REV. F SHEET 1 OF 2	
DATE 99.12.13		TITLE MOUNTING LUG		SCALE 1:1	
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED  
199-12-21 05

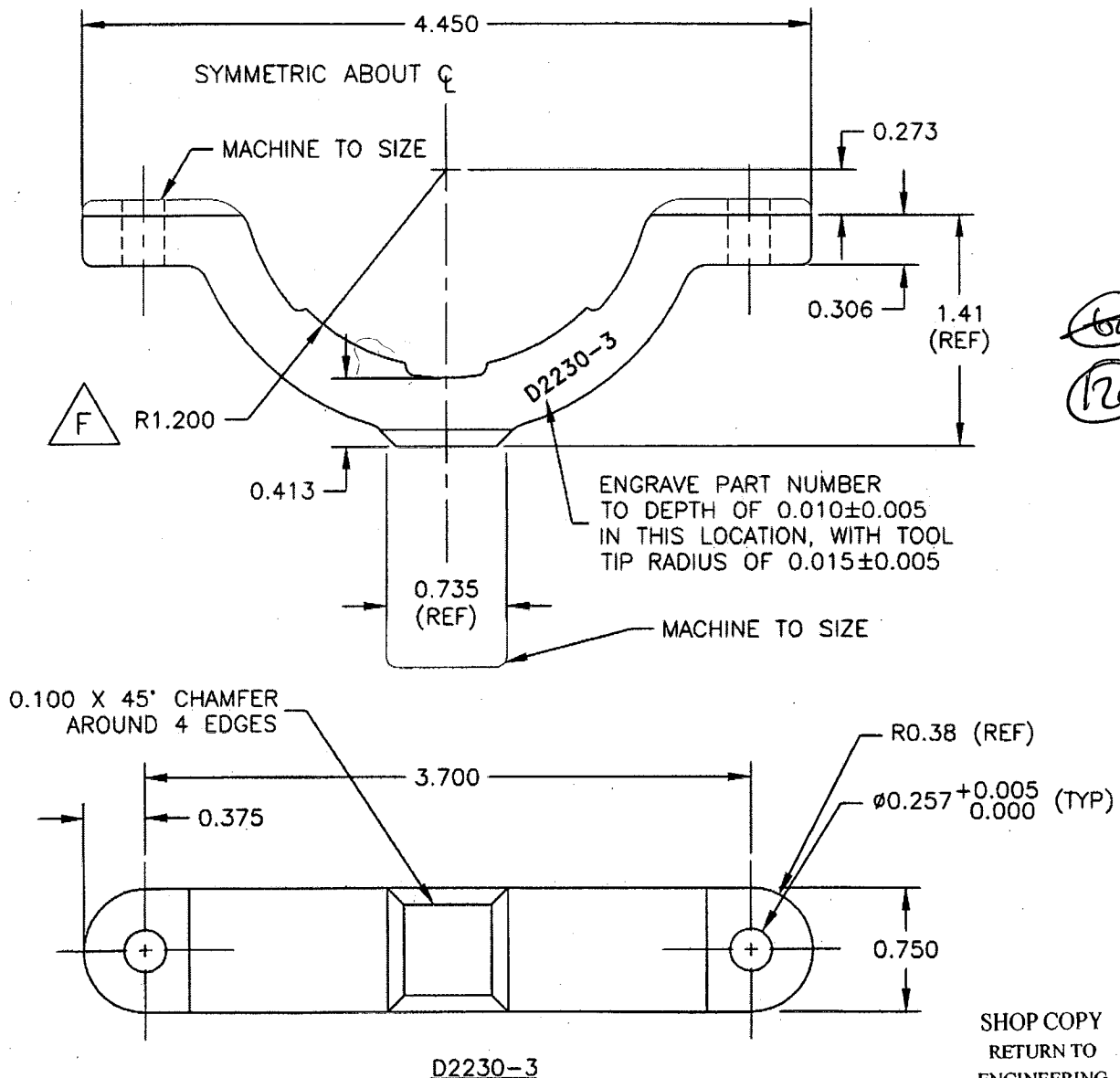


MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40391

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

**RELEASED**  
49.12.21 DS

MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40341



## ORDER CONFIRMATION

Order No.: 6711  
Date: Jul 10, 2008  
Page: 1  
Ship Date: Jul 25, 2008

**Sold To:**

Dart Aerospace Ltd.  
Att. Linda Lacelle  
1270 Aberdeen Street  
Hawkesbury, Ontario K6A 1K7

**Ship To:**

Dart Aerospace Ltd.  
Att. Linda Lacelle  
1270 Aberdeen Street  
Hawkesbury, Ontario K6A 1K7

Business No.: 867 061 723

Ordered	Unit	Description	Unit Price	Amount
200	Each	D2230-3 Mounting Lug  Terms: 2%/10, Net 30 Delivery: As above Shipped By our truck	10.40	2,080.00
Thank you for your order!			Freight	0.00
			GST 6 %	104.00
			Total Amount	2,184.00

P.O. Box 781  
Tel. 613) 678-3957 & 678-2782

20 Terry Fox Drive  
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0  
metec@metec.ca / www.metec.ca





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

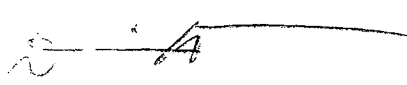
SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3	Mounting Lug	6711
	MATERIAL: supplied by DART D2423 B33310		

We hereby certify that the above parts were made in conformance with applicable drawings. *S. 8/1/08*

METEC Metal Technology Inc.

  
Denise Fobinson

Vankleek Hill, August 1, 2008